

Work Order ID 79145

79145

Page 1

January-20-12 1:43:49 PM

Item ID: D4327-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle
 Start Date: 20/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 03/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M. L. J Date: 12/01/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4327	A

100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-2-14

(4)

B12-2-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79145

Page 2

N900040100

Setup Start *NS1*

Stop ***NS2***

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00
0.00

120

QC Memo

Quality Control

124	0.00
-----	------

124

Small Fab	Memo	0.00
-----------	------	------

Small Fab Form as per dwg

126	0.00
-----	------

126

QC	Memo	0.00
----	------	------

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 Start Date: 20/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
135	QC3- Inspect Part Finish	0.00							
135									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>ST 1392</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									

(4) 746 12-3-19

4x0 M/12/03/20

(4x) SP 12-03-21.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 20/01/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 03/02/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS 12/03/21

MLJ 12/03/21

4

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

January-20-12 1:43:53 PM

Work Order ID: 79145

79145

Parent Item: D4327-3

D4327-3

Parent Item Name: Angle

Start Date: 20/01/2012

Required Date: 03/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.04.04 new issue DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	134.3184	0.398	1.675789			

M2024T3S 040

2024-T3 .040 sheet

**

B12-2-14

Location

Loc Qty

Loc Code

MAT022

134.318421

117684

26.318421

120196

108

120605

(4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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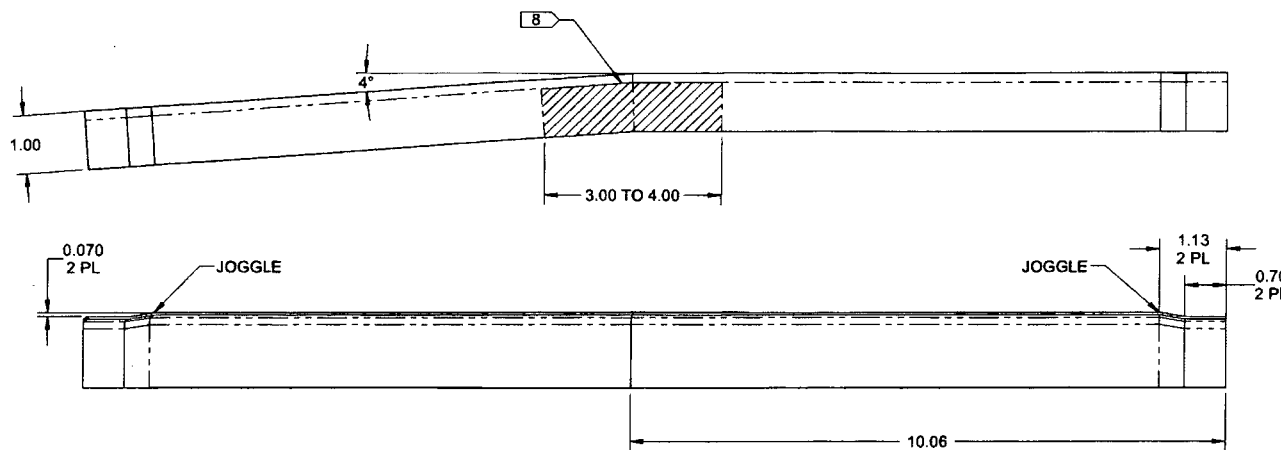
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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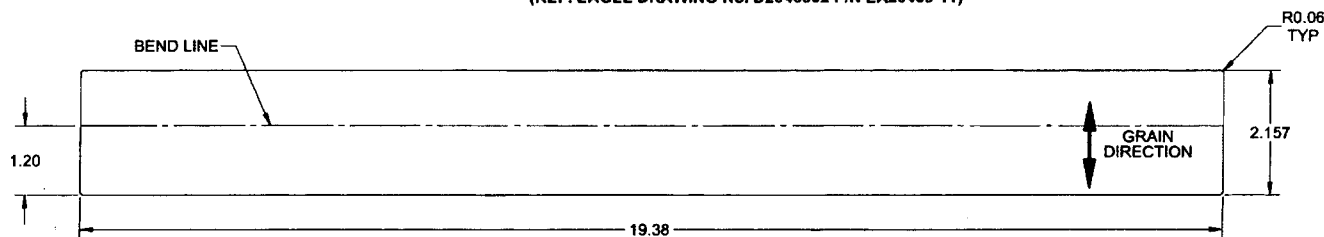
NOTE: Date & initial all entries

SHOOT COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMIT FOR ELEMENT

79145-4.0
12/01/20



D4327-1 ANGLE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)



D4327-1F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs
- 8) SHRINKING AREA TO SUIT DT9753 TEMPLATE

A		NEW ISSUE		RF	10.11.22
REV		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D4327	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		VRD PARTS	NTS		
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

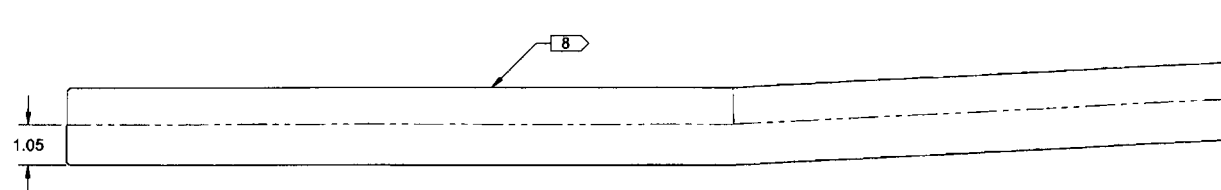
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

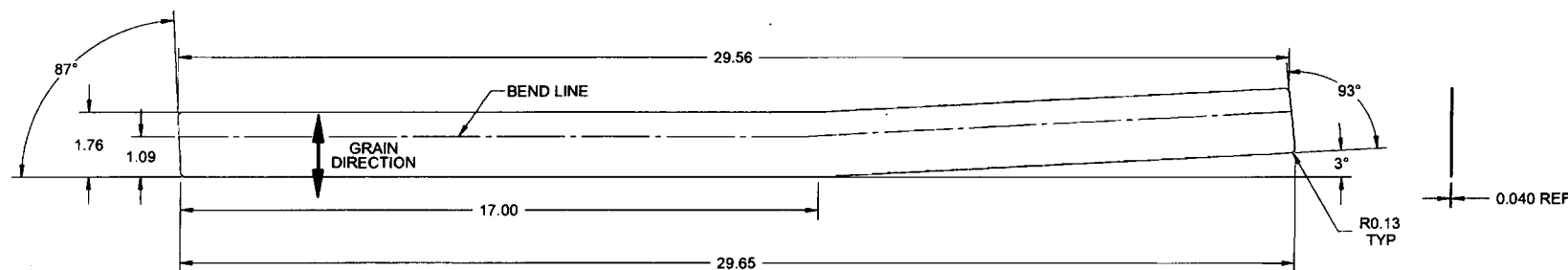
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79145



D4327-3 ANGLE
(MAKE FROM D4327-3F FLAT PATTERN)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)



D4327-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs
- 8) FORM TO SUIT DOOR PROFILE

RELEASED
R 2011-04-06

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4327	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	VRD PARTS	NTS
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